ASAP

Work Order ID 95335

95335

Page 1

January-09-13	10:15:21 AM	·		95.	າ.າຕ 						
Item ID: Revision ID:	D3893-1			Accept	*N900	040	100)* s	etup Stai	* *N	S1*
Item Name:	DOUBLER	10							Sto	*N	S2*
Start Date:	1/07/13	Start Qty: 6.00	*6*		Cust Item	ID:					
Required Date:	: 1/17/13	Req'd Qty: 6.00	*6*		Customer:						
Reference:			()	•							
Approvals:	Process Plan	1: ML丁	Date: \3-0\-	\\ Tooling:	D	ate:	 -	R	tun Sta	I <i>Z</i> I	R1*
		··· · · · · · · · · · · · · · · · · ·		SPC (Y/N):	D	ate:			Sto	*N	R2*
Sequence ID/ Work Center I		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
D3893	REV	.A									
100				0.00							
100 Waterjet		Memo		0.00				10	0		JM13-1-29
FLOW CNC Water	jet	1-Cut as per Dwg Rev: Prog Rev:									
-		2- Deburr if	necessary								
110		QC2- Inspect parts off m	nachine FAI/FAIB	0.00							
110 QC Quality Control		Мето		0.00				10			Jm13-122

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-O	O	NFORM	MANCE / UP	DATE				_	
											QA	Closed:	Da	te:	
Work Ord	er:					DISPOSITION		AGAINST DE				RTMENT/	PROCESS		
Part No				Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Machining Small Fab moforming Finishing Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other		
												· · · · · · · · · · · · · · · · · · ·			
Root			١	۱		ption of work order update	ļ	Initial		ction	1	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	cription	╁	Date	Verificatio	n	QC Inspector
Doc/Data	<u> </u>														,
Equip/Tooling	<u> </u>														
Operator	<u> </u>	1]												
Material	┝	i													
Setup	\vdash														
Other															
Process	L	ļ									İ			ļ	
Supplier															
Training	<u> </u>	1													
Unapproved							<u>L</u>			<u> </u>	1				
							AUI	LT CATE	GORY						
Landi	_	3				General		1		_	7			_	1
	Bending					Bend	<u> </u>	Grain		<u> </u>	-1	alized		<u> </u>	Pressure/Forced
	Centre Not Concentric to O/S		o/s	BOM/Route	<u> </u>	Hardwa			-	er/Under		\vdash	Temperature/Cure		
	Cracks			Broken/Damaged		4	on Incomplete	_	┥	rt Incorrec			Weld		
	Crushed/Crimped.				<u>_</u>	Burrs		-1	ions Incomplete,	/Unclear	-	rt Lost/Mi	ssing	L	Wrong Stock Pulled
	Cuffs					Contamination		Mainte				rt Moved			
		Heat Treat				Countersink		Mislabe	led		Positioned Wrong				
		Inspection Strip in Tube				Cut Too Short		Misread	i		Pov	wer Loss/	Surge	1	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 95335 *95335* Page 2 January-09-13 10:15:21 AM Item ID: D3893-1 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: **DOUBLER** 1/07/13 Start Qty: 6.00 **Start Date: Cust Item ID: Req'd Qty:** 6.00 Required Date: 1/17/13 **Customer:** Reference: Run Process Plan: Date: Tooling: Approvals: Date: Stop Date: SPC(Y/N): OC: Date: Sequence ID/ Tool ID Tool # Plan Reject Operation Accept Reject Insp. Set Up/ Work Center ID Code Qty Number Stamp **Qty Description Run Hours** 120 QC8- Inspect parts - second check *120* 0.00 13-130 QC Memo Quality Control Identify as per dwg & Stock Location: 130 0.00 *130* 1 1 N Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 *140* QC 0.00 Memo Quality Control

MB-01-20

										DQA:	Date	e:		
NCR: Y	es / N	0			WORK ORDER NON-C	CON	NFORM	MANCE / UP	DATE	0.1.611				
										QA Closed:	Date	5:		
Work Orde	or.				DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Part No				Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Small Fab	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root				Descri	ption of work order update	1	nitial	Act	ion	Sign &				
Cause	Dat	e Step	Qty	c	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector		
Doc/Data							·							
Equip/Tooling		l												
Operator [
Material []				
Setup														
Other			1											
Process												-		
Supplier				į										
Training														
Unapproved														
					F	AUL	T CATE	GORY						
Landir	ng Gear				General		_			_				
	Bending Bend Grain			Ovalized		Pressure/Forced								
	Centre Not Concentric to O/S BOM/Route Hardware			Over/Under	tolerance	Temperature/Cure								
			Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld				
	Crushed/Crimped.			Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/M	issing	Wrong Stock Pulled			
	Cuffs		Contamination		Mainte	nance		Part Moved	_					
	Heat Treat			Countersink		Mislabe	led		Positioned \	Vrong				
	Inspection Strip in Tube			Cut Too Short		Misread	1		Power Loss/	'Surge	Other			
ļ	Ripples in Bend				Drill Holes		Offset			_	_			

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

January-09-13 10:15:20 AM

Work Order ID:

95335

Parent Item:

D3893-1

Parent Item Name:

DOUBLER

Start Date: 1/07/13

Required Date: 1/17/13

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA		Purchased	No			100	sf	318.3400	0.018	Q-H36844		V	
304/316 0.018 SHEET										0,2			Jm 13-1-
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT020		318.34							
				117	798	69.28				·			
				122	753	97.06							
•				123	135	152			123	3 <i>135</i>			

										DQA	Date:			
NCR: Yes	/ No			V	VORK ORDER NON-	CONF	ORN	AANCE / UF	PDATE	QA Closed	: Date:			
Work Order:					DISPOSITION				AGAINST DEPARTMENT/PROCESS					
Part No				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		Rec/Sto	Water Jet od. Eng. Coor. ore/Packaging Supplier	Engineering Quality Other				
Root				I	n of work order update	Init	ial	A	ction	Sign &				
Cause	Date	Step	Qty	or N	lon-conformance	Chief	Eng	Des	cription	Date	Verification	QC Inspector		
Doc/Data														
Equip/Tooling						1	l							
Operator														
Material														
Setup														
Other												ļ		
Process												:		
Supplier														
Training							- 1							
Unapproved	1		}				1							
		1		<u> </u>	F	AULT (CATE	GORY		*		•		
Landing (Gear				General									

Bending		Bend	Grain	Ovalized	L	Pressure/Forced
Centre Not Concentric to O/S		BOM/Route	Hardware	Over/Under tolerance		Temperature/Cure
Cracks		Broken/Damaged	Inspection Incomplete	Part Incorrect	L	Weld
Crushed/Crimped.		Burrs	Instructions Incomplete/Unclear	Part Lost/Missing		Wrong Stock Pulled
Cuffs		Contamination	Maintenance	Part Moved		
Heat Treat		Countersink	Mislabeled	Positioned Wrong		_
Inspection Strip in Tube		Cut Too Short	Misread	Power Loss/Surge		Other
Ripples in Bend		Drill Holes	Offset			
Torque Waves in Extrusion		Drawing	Out of Calibration			
Turning Sequence		Finish	Out of Sequence			
Wave/Twist in Tube	Г	Folio	Outside Dimensions			

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	95335
Description: Doubler	Part Number:	D3893-1
Inspection Dwg: D3893 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

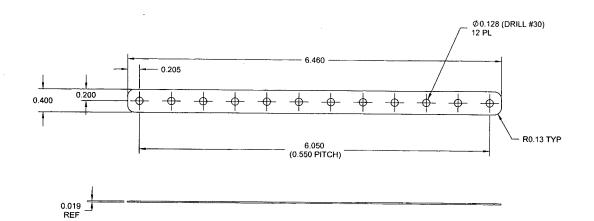
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	0.125	-		V	Jamos
0.200	+/-0.010	0.205	_		v	
0.400	+/-0.010	0.403"	-		V	
0.205	+/-0.010	0.209"	,		V	
0.550	+/-0.010	0.553-	-		ν	
6.050	+/-0.010	6.053"			V	
0.019	+/-0.010	0.017"	-		~	
					errado a reconstruir de la constanta de la cons	
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						· den

Measured by:	Jm	Audited by:	SMB	Prototype Approval:	N/A
Date:	13-1-29	Date:	13-1-30	Date:	N/A

Rev	Date	Change		ised by	Approved	ľ
Α	09.10.22	New Issue	KJ	del		ŀ
				171		

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SHOPCORY REITRY ENGINEERS . . UNCONTROLL TO A 19 SUBJECT TO A CO. Wire Add to the

95335 ML>

13-01-11

D3893-1 DOUBLER

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NOTES:
1) MATERIAL: AISI 304 SS SHEET, 0.01875 THICK (26 GAUGE) PER MIL-S-5059 OR ASTM A240 OR ASME SA240 (REF DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK CHARD EDGES 0.005 TO 0.014 MAY

**) OWN 3: INCIDES ONLESS OTHERWISE NOTED 55) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3893-1" USING FINE POINT PERMANENT INK MARKER 7) WEIGHT: 0.01 lbs

Α NEW ISSUE 09.01.30 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3893 MFG. APPR. SHEET 1 OF 1 APPROVED TITLE SCALE **DOUBLER** DE APPR. COPYRIGHT © 2009 BY DART AEROSPACE LTD
INSTRUMENT AND COMPOSITION AND IN HUMBLE ON THE EXPRISES COMPOSITION OF THE EXPRISES COMPOSITION OF THE EXPRISES COMP NTS DATE 09.01.30